

Work Order ID 135971

Wednesday, August 26, 2015 10:07:16 AM

135971

Ship 31 *st* Page 1

Item ID: \D2332-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Prop Assembly 8.00"
 Start Date: 8/26/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/26/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *unf* Date: *5-8-26* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2332	Rev C1 <i>✓</i>								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Cut to length as per Dwg D2332 (D2332-7) Locking CollarCut to length as per Dwg D2332 (D2332-5) Stop Pin Deburr								
110		0.00							
110	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch or form to length as per Dwg D2332 (D2332-11) using DT8012(Note: Make (2) D2332-11 Prop Arms per assembly.)								
120		0.00							
120	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Drill hole in D2332-1 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)2-ensure no foreign objects inside fo tube and deburr								

1 *FF* *AUG 31 2015*
2 *FF* *AUG 31 2015*
2 *FF* *AUG 31 2015*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ¹ ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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 Start Date: 8/26/2015 Start Qty: 2.00 *2* Cust Item ID:
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									DAS
QC	Memo	0.00							38
Quality Control									9-89
									AUG 31 2015
200	Identify as per dwg & Stock Location: <u>367</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

AUG 31 2015

15/8/31
 MF
 15-8-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER :																			

Picklist Print

Wednesday, August 26, 2015 10:07:15 AM

Page 1
2

Work Order ID: 135971

135971

Parent Item: D2332-043

D2332-043

Parent Item Name: Lid Prop Assembly 8.00"

Start Date: 8/26/2015

Required Date: 8/26/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B03.07.08Re-issue 8.00"" longKJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A		Purchased	No			180	Each	351.0000	1	2			
AN4-4A									**		FF	AUG 31 2015	

BOLT

Location	Loc Qty	Loc Code
FP001	24	
m125709	24	
ST325A	327	
m129390	327	

AN960JD416L NAS1149D0416J Purchased

No

180

Each

0.0000

3

6

***AN960.1D416I ***

M131511

**

6

FF

AUG 31 2015

Washer

M304R.250

Purchased

No

110

f

8.9579

0.1083

0.228

M304R 250

**

FF

AUG 26 2015

304 SS Round bar .250

Location	Loc Qty	Loc Code
MAT028	8.957894	
122682	8.957894	

M304TR0.500W.035

Purchased

No

180

f

93.1486

1.6666

3.508632

M304TR0 500W 035

**

FF

AUG 26 2015

304 RD Tube .500 x .035W

Location	Loc Qty	Loc Code
GA002	93.1486	
m128495	26.5	
m132775	9	
m132872	57.6486	

3.5086

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Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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Page 2

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Parent Item: D2332-043

D2332-043

Parent Item Name: Lid Prop Assembly 8.00"

Start Date: 8/26/2015

Required Date: 8/26/2015

Start Qty: 2.00

Required Qty: 2.00

M304TR1.000W.049

Purchased

No

100

f

96.8489

0.4219

0.888211

M304TR1 000W 049

304 RD Tube 1.00 x .049W

FF

AUG 26 2015

Location

Loc Qty

Loc Code

GA002

96.848947

125250

56.848947

m130551

40

0.888211

MS21042L4

Purchased

No

100

Each

2,532.000

1

2

MS21042L 4

Locknut

FF

AUG 31 2015

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

124

m127813

124

2

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2236

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2056

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